

# Work Order ID 50303

July 14, 2009 11:46:14 AM



Page 1

Item ID: D3407-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Stem

Start Date: 7/15/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 20.00



Customer:

Reference:

*Jul 09.07.16*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA596 Rev *W/A* & Dwg D3407 Rev: *E* 12-Deburr

*SP 09/07/19*

*22*



*P10*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SP 09/07/19*

*22*



120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*SP 09/07/29*

*22*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3407-1 PAR #: N/A Fault Category: Machin NCR: Yes No DQA: M Date: 09-08-05  
acceptable / use as is QA: N/C Closed: 7 Date: 08-08-17

NCR: <u>50303</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/07/19</u>	<u>100</u>	<u>9 parts out of tolerance</u> <u>by .005 on dimension</u> <u>4.250</u> <u>R.C. Op. error</u>	<u>[Signature]</u> <u>09/07/19</u>	<u>Acceptable deviation.</u> <u>OK</u> <u>MD</u> <u>09/07/19</u>	<u>SD</u> <u>09/07/19</u>	<u>md</u> <u>09/07/29</u>	<u>[Signature]</u> <u>par M.P.</u> <u>approval</u>	<u>[Signature]</u> <u>09/07/29</u>

NOTE: Date & initial all entries

**Work Order ID 50303**

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Item ID: D3407-1

Accept



Setup Start



Revision ID: E

Stop



Item Name: Stem

Start Date: 7/15/09

Start Qty: 20.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg &amp; Stock Location: 93

0.00

22x

9/7/03

SP

Memo

0.00

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

09/07/31

Memo

0.00

Quality Control

MF 09-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

July 14, 2009 11:46:14 AM

Work Order ID: 50303

Parent Item: D3407-1RevE

Parent Item Name: Stem



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174R0.750 		Purchased	No			100	f	67.2500	7.7053			
17-4 round bar .750												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	67.25	
110777	19.25	
111642	48	

3.5 ft  
8 ft

5/10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	50303
<b>Description: Tow Ring</b>		<b>Part Number:</b>	D3407-1
<b>Inspection Dwg: D3407      Rev: E</b>		<b>Page 1 of 1</b>	

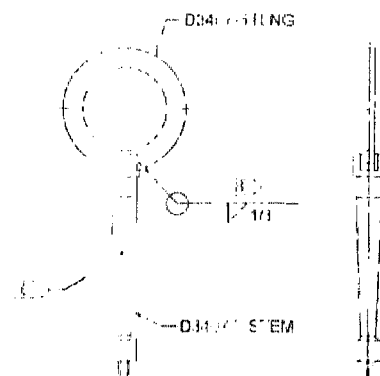
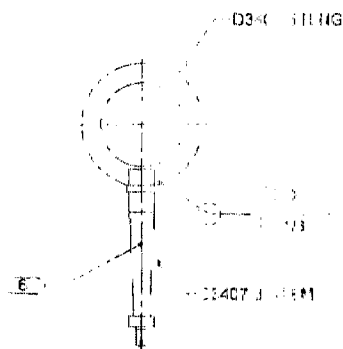
### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/			
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/			
Major Ø	Max: 0.249 Min: 0.2425	.246	/			
Ø0.625	+/-0.010	Ø.626	/			
Ø0.363	+/-0.010	Ø.363	/			
Ø0.750	+/-0.010	Ø.748	/			
R0.100	+/-0.010	R.100	/			
0.470	+/-0.010	.470	/			
0.500	+/-0.010	.496	/			
3.250	+/-0.010	3.250	/			
4.250	+0.000/-0.010	4.240	/			
5.270	+/-0.010	5.272	/			
0.150	+/-0.010	.152	/			
0.550	+/-0.010	.555	/			
0.625	+/-0.010	.624	/			
0.250	+0.010/-0.000	.256	/			

<b>Measured by:</b> SA	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/19	<b>Date:</b> 09/07/29	<b>Date:</b>	N/A

Rev	Date	Change		
A	06.09.19	New Issue		
B	07.07.18	Tolerances for diameters updated per Machinists		
C	08.05.14	Dimensions updated per Dwg Rev D		



FILED AS 11-15-57

\*\*\*\*\*049 LOW RING

50303

140T: 1  
150T: 1  
160T: 1  
170T: 1  
180T: 1  
190T: 1  
200T: 1  
210T: 1  
220T: 1  
230T: 1  
240T: 1  
250T: 1  
260T: 1  
270T: 1  
280T: 1  
290T: 1  
300T: 1  
310T: 1  
320T: 1  
330T: 1  
340T: 1  
350T: 1  
360T: 1  
370T: 1  
380T: 1  
390T: 1  
400T: 1  
410T: 1  
420T: 1  
430T: 1  
440T: 1  
450T: 1  
460T: 1  
470T: 1  
480T: 1  
490T: 1  
500T: 1  
510T: 1  
520T: 1  
530T: 1  
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610T: 1  
620T: 1  
630T: 1  
640T: 1  
650T: 1  
660T: 1  
670T: 1  
680T: 1  
690T: 1  
700T: 1  
710T: 1  
720T: 1  
730T: 1  
740T: 1  
750T: 1  
760T: 1  
770T: 1  
780T: 1  
790T: 1  
800T: 1  
810T: 1  
820T: 1  
830T: 1  
840T: 1  
850T: 1  
860T: 1  
870T: 1  
880T: 1  
890T: 1  
900T: 1  
910T: 1  
920T: 1  
930T: 1  
940T: 1  
950T: 1  
960T: 1  
970T: 1  
980T: 1  
990T: 1  
1000T: 1

[illegible]



